

**Work Order ID 65253**

January 10, 2011 10:34:20 AM



Page 1

Item ID: D3573-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Adapter

Start Date: 1/10/11 Start Qty: 8.00



Cust Item ID:

Required Date: 1/19/11 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: 

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3573

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 3.500" long

B.A 11/03/23

8 0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA677 and Dwg D3573

B.A 11/03/29

8 0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B.A 11/03/29

8 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 65253

January 10, 2011 10:34:20 AM



Page 2

Item ID: D3573-7

Accept



Setup Start



Revision ID:

Item Name: Adapter

Stop



Start Date: 1/10/11 Start Qty: 8.00



Cust Item ID:

Required Date: 1/19/11 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

*mk 11/03/29*



QC

Memo

0.00

Quality Control

*8*

*0*

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

*8*

*BL 11-3-30*

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

*M115128*

START TIME:

*10:30*

OVEN TEMPERATURE:

*320°*

FINISH TIME:

*11:00*

*8*

*BL 11-3-30*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

**Work Order ID 65253**

January 10, 2011 10:34:21 AM



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Item ID: D3573-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Adapter

Start Date: 1/10/11 Start Qty: 8.00



Cust Item ID:

Required Date: 1/19/11 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				8	0	44	11/03/30
170  Packaging Packaging	Identify as per dwg & Stock Location <i>Syhan</i>  Memo	0.00  0.00						80	11/3/30
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							11/3/31 <i>[Signature]</i> NF 11-03-30

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

January 10, 2011 10:34:19 AM

Page 1

Work Order ID: 65253

Parent Item: D3573-7

Parent Item Name: Adapter



Start Date: 1/10/11

Required Date: 1/19/11

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-01-29 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X02.50 0		Purchased	No			100	f	8.4689	0.292	2.458947			



6061-T6 Bar .500 x 2.50



Location

Loc Qty

Loc Code

MAT02

8.46891

8.46891

M116623

846891

2.4589 ft

B.A 11/03/23

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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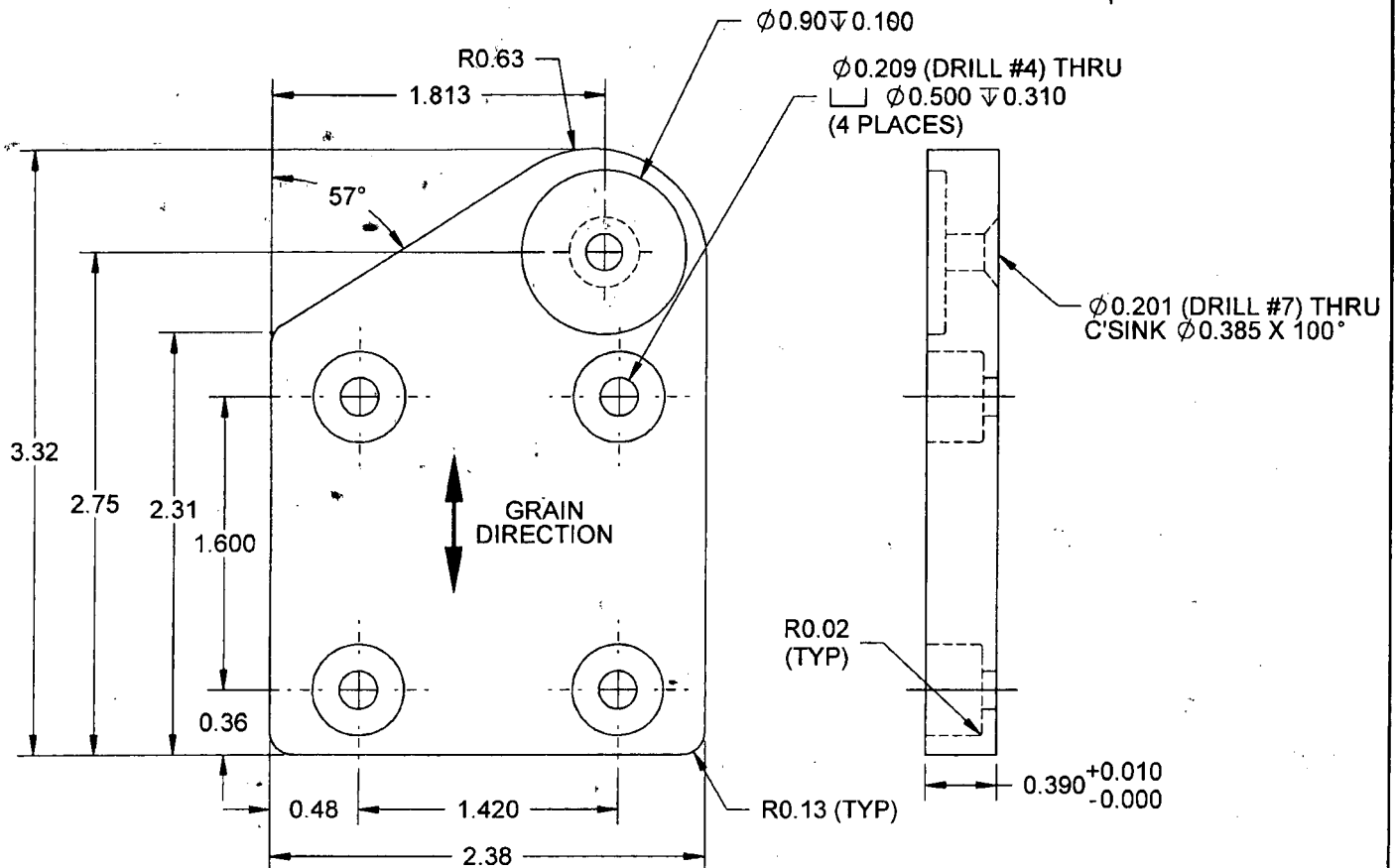


**DART**

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3573</b>	REV. A SHEET 4 OF 4
DATE <b>07.02.19</b>	TITLE <b>ADAPTER</b>		SCALE 1:1

**RELEASED**  
07.04.02

#65253



**D3573-7 ADAPTER (SHOWN)**  
**D3573-8 ADAPTER (OPPOSITE)**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR  
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160  
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-7/-8" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 65253
<b>Description:</b> Adapter		<b>Part Number:</b> D3573-7
<b>Inspection Dwg:</b> D3573	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.32	+/-0.030	3.313	✓		VERN	GA-01
2.75	+/-0.030	2.750	✓		"	"
0.36	+/-0.030	0.360	✓		"	"
1.600	+/-0.010	1.600	✓		"	"
0.48	+/-0.030	0.479	✓		"	"
2.38	+/-0.030	2.375	✓		"	"
1.420	+/-0.010	1.420	✓		"	"
1.813	+/-0.010	1.814	✓		"	"
Ø0.209	+0.005/-0.001	Ø0.211	✓		"	"
Ø0.201	+0.005/-0.001	Ø0.203	✓		"	"
Ø0.90 x 0.100	+/-0.010	Ø0.906 x .101	✓		"	"
Ø0.500 x 0.310	+/-0.010	Ø0.500 x 0.310	✓		"	"
0.390	+/-0.010	0.391	✓		"	"
Ø0.385 x 100°	+/-0.010 x 0.5°	Ø0.387 x 100°	✓		"	"
R0.63	+/-0.030	R0.625	✓		R-6	ref.
R0.13	+/-0.030	R0.125	✓		"	"
R0.02	+/-0.030	R0.015	✓		"	"

<b>Measured by:</b> B.A	<b>Audited by:</b> <i>amr</i>	<b>Prototype Approval:</b> N/A
<b>Date:</b> 11/03/29	<b>Date:</b> 11/03/29	<b>Date:</b> N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	10.04.01	New Issue	KJ <i>[Signature]</i>	<i>[Signature]</i>

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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